

Radilon® S 35HRD 100 M NAT

Polyamide 6

Radici Plastics

Message:

PA6 medium-high viscosity injection moulding grade. Natural colour.

Suitable for moulding of high thickness items, such as wheels and chairs.

Also fit for gas-assisted injection technology.

ISO 1043 : PA6

General Information				
Features	Medium-high Viscosity			
Uses	Seats			
	Wheels			
RoHS Compliance	RoHS Compliant			
Appearance	Natural Color			
Processing Method	Injection Molding			
Resin ID (ISO 1043)	PA6			
Physical	Dry	Conditioned	Unit	Test Method
Density	1.14	--	g/cm ³	ISO 1183
Water Absorption				ISO 62
Saturation, 23°C, 2.00 mm	10	--	%	
Equilibrium, 23°C, 2.00 mm, 50% RH	2.9	--	%	
Viscosity Number (H ₂ SO ₄ (Sulphuric Acid))	205	--	cm ³ /g	ISO 307
Mechanical	Dry	Conditioned	Unit	Test Method
Tensile Modulus	2900	1250	MPa	ISO 527-2/1A/1
Tensile Stress (Yield)	75.0	45.0	MPa	ISO 527-2/1A/50
Tensile Strain (Yield)	4.0	30	%	ISO 527-2/1A/50
Nominal Tensile Strain at Break	65	> 100	%	ISO 527-2/1A/50
Flexural Modulus ¹	2500	--	MPa	ISO 178
Flexural Stress ²	100	--	MPa	ISO 178
Impact	Dry	Conditioned	Unit	Test Method
Charpy Notched Impact Strength				ISO 179/1eA
-30°C	5.0	--	kJ/m ²	
23°C	7.7	20	kJ/m ²	
Thermal	Dry	Conditioned	Unit	Test Method
Heat Deflection Temperature				

0.45 MPa, Unannealed	165	--	°C	ISO 75-2/Bf
1.8 MPa, Unannealed	60.0	--	°C	ISO 75-2/Af
Vicat Softening Temperature	195	--	°C	ISO 306/B50
Melting Temperature ³	220	--	°C	ISO 11357
Electrical	Dry	Conditioned	Unit	Test Method
Surface Resistivity	1.0E+12	1.0E+10	ohms	IEC 60093
Volume Resistivity	1.0E+15	1.0E+13	ohms·cm	IEC 60093
Comparative Tracking Index	600	--	V	IEC 60112
Flammability	Dry	Conditioned	Unit	Test Method
Burning Rate	0.0	--	mm/min	FMVSS 302
Flame Rating (0.800 mm)	HB	--		UL 94
Glow Wire Flammability Index (2.00 mm)	750	--	°C	IEC 60695-2-12
Injection	Dry	Unit		
Drying Temperature - Desiccant Dryer	80.0		°C	
Drying Time - Desiccant Dryer	2.0 to 4.0		hr	
Dew Point - Desiccant Dryer	< -20.0		°C	
Suggested Max Moisture	0.15		%	
Processing (Melt) Temp	250 to 280		°C	
Mold Temperature	70.0 to 80.0		°C	
Injection Rate	Moderate			
NOTE				
1.	2.0 mm/min			
2.	2.0 mm/min			
3.	10°C/min			

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Susheng Import & Export Trading Co.,Ltd.

Tel: +86 21 5895 8519

Phone: +86 13424755533

Email: sales@su-jiao.com

No. 215, Lianhe North Road, Fengxian District, Shanghai, China



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